

# Paola Equipment

## FACILITY BUILDINGS BAY AND CRANE DATA

| Bay Dimension | Type Crane | Quantity | Capacity     | Height Under Hook | Electric or Manual |
|---------------|------------|----------|--------------|-------------------|--------------------|
| 75 x 655      | Overhead   | 2        | 10 & 15 ton  | 26'               | Electric           |
| 60 x 655      | Overhead   | 2        | 10 ton       | 26'               | Electric           |
| 82 x 250      | Overhead   | 2        | 20 ton       | 26'               | Electric           |
| 63 x 320      | Gantry     | 1        | 150 ton      | 33'               | Hydraulic          |
| 40 x 140      | Overhead   | 2        | 5 & 10 ton   | 16'               | Electric           |
| 36 x 90       | Overhead   | 1        | 5 ton        | 16'               | Electric           |
| Yard          | Crawler    | 2        | 50 & 175 ton | 70'               | -                  |
| Yard          | Gantry     | 1        | 50 ton       | 45'               | -                  |

### VESSEL SIZE AND WEIGHTS THAT CAN BE HANDLED

|           |          |
|-----------|----------|
| Diameter: | 15'      |
| Length:   | 150'     |
| Weight:   | 800,000# |

### SKID MOUNTED EQUIPMENT

16'x16'x80'

### QUALIFIED WELDING PROCEDURES

We have over 600 procedures qualified to ASME Section IX.

### Hydraulic Presses

3,000 ton  
2,000 ton  
1,500 ton

### CUTTING EQUIPMENT

#### Capacity

|                          |            |
|--------------------------|------------|
| Plate Shears:            | 3/8" x 10' |
| Automatic Flame Cutting: | To 7 1/2"  |
| Plasma Cutting:          | To 3"      |
| Saw:                     | 40" x 40"  |

### WELDING EQUIPMENT

#### Welding Machines

|                  |                             |
|------------------|-----------------------------|
| AC/DC available: | 48-Current Range<br>200-900 |
| DC available:    | 37-Current Range<br>200-900 |
| SAW available:   | 32                          |
| Orbital          | GMAW/FCAW                   |

#### Welding Positioners

Powered available: 28

#### Shell Turning Rolls

Powered available: 29

### MACHINE TOOLS (MAXIMUM SIZE AND TYPE)

|                            |   |
|----------------------------|---|
| 4 Vertical Boring Mills:   | up to 84" swing                                 |
| 5 Horizontal Boring Mills: | up to 84" bar                                   |
| Lathes:                    | 16" to 120" swing -<br>46' max. between centers |
| Drill Presses:             | to 19" column -<br>6' arm                       |
| Punches:                   | No. 2 1/2 Buffalo<br>Iron Worker                |

### PLATE ROLLS

|                 |                     |
|-----------------|---------------------|
| Quantity        | 4                   |
| Type            | Initial and Pyramid |
| Plate Thickness | Maximum 7 1/4"      |
| Length: Maximum | 13'                 |
| Minimum I.D.    | 13"                 |

### HYDROSTATIC MEDIUM

Water To 45,000 psi  
Deionized water available

### PLATE BRAKES

|                  |                      |
|------------------|----------------------|
| Quantity:        | 3                    |
| Type:            | Crimping and Bending |
| Capacity:        | 750 ton              |
| Plate Thickness: | 7 1/2"               |
| Length:          | 12'                  |

### HEAT TREATING FURNACES

Car bottom - 3 gas fired - Annealing, Austenitizing, Normalizing, Quenching and Tempering, Stress Relieving, Automatic Temperature Controls with Strip Chart Recorders for both Furnace and Contact.

Thermocouples (furnace calibrated to MIL-H-6875-F).

(2) Water Quenching Facilities  
Multiple impeller quench tanks adjacent to furnaces to 45,000 Gal. Max. Quench to 14' Dia. x 20' Lg.

### NONDESTRUCTIVE TESTING EQUIPMENT

#### Radiographic Facilities Available

#### Magnetic Particle Inspection Machines

Number: 5

Type: Magnaflux

#### Liquid Penetrant Inspection Equipment

Type: Solvent or water washable (visible)

### CHEMICAL TESTING EQUIPMENT

Port-A-Spec

### PHYSICAL TESTING EQUIPMENT

|                         |                       |                      |
|-------------------------|-----------------------|----------------------|
| Tensile Testing:        | Tinius-Olsen          | Capacity: 60,000     |
| Bending Facilities:     | Tinius-Olsen          | Capacity: 60,000     |
| Impact Testing:         | Tinius-Olsen          | Capacity: 264 ft-lbs |
|                         | Charpy to -50 deg. F. |                      |
| Hardness Testers        | Rockwell and Brinell  |                      |
| 1 - Drop Weight Testers |                       |                      |

### OTHER TESTING EQUIPMENT AVAILABLE

MS leak test, halogen leak test, portable Brinell testers, ultraviolet light, ion tester for fluorides and chlorides in water.